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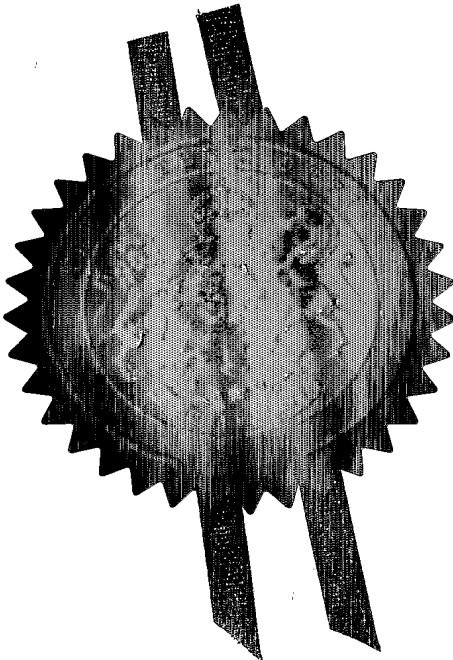
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3. Full name, address and postcode of the
or of each applicant (underline all surnames)

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Patents ADP number (*if you know it*)

8546061001

If the applicant is a corporate body, give
country/state of its incorporation

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4. Title of the invention

Nitrogen Inerting System

5. Name of your agent (*if you have one*)

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11.

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NITROGEN INERTING SYSTEM

5 The present invention relates to an energy
efficient gas separation system that can separate
atmospheric air into a highly enriched nitrogen fraction
and slightly enriched oxygen fraction. The nitrogen
rich air from the gas separation system contains enough
10 nitrogen to enable the air to be used as an inert
atmosphere inside tanks or vessels containing flammable
or volatile materials, such as fuels, solvents and
chemicals, to reduce the risk of fire and explosion.

 A composite hollow fibre membrane is used as the
15 gas separation medium. The membrane may consist of a
polyethersulfone fibre tube coated on the outside with a
very thin layer of selective polymer comprising cross-
linked and non cross-linked polydimethylsiloxane.
A preferred feature of the hollow fibre membrane is that
20 the fibre tube is subjected to a special modification
technique that significantly increases the gas
permeability properties of the fibre before it is coated
with the selective outer layer.

 The gas separation membrane is described in detail
25 in UK Patent Application No. 0301139.2, a copy of which
is attached as Appendix 1 hereto. The modification
technique involves soaking the outer surface of the
fibre tube with a solution of acetone, displacing the
acetone solution with distilled water and then quickly
30 drying the fibre tube. Repeated cycles of soaking and
drying results in a fibre tube with up to twice as many
pores in its structure as unmodified fibre.

 The modification process also changes the surface
characteristics of the fibre tube so that the outer
35 surface of the fibre tube is able to support a very
thin, uniform, defect free layer of the selective
polydimethylsiloxane polymer. This combination of a
very porous fibre tube and a very thin selective coating
results in a composite hollow fibre membrane that has

relatively high gas permeability and a reasonable degree of gas selectivity.

Because the hollow fibre membrane has high permeability properties, the membrane is able to
5 separate normal atmospheric air into nitrogen and oxygen rich fractions by the application of a relatively low differential pressure between the outside of the membrane and the hollow core of the membrane. For example, a light vacuum of about 0.5 bar applied to the
10 hollow core of the membrane is sufficient to draw atmospheric air through the wall of the membrane and allow the membrane to selectively enrich the air with oxygen. The permeate oxygen rich air accumulates in the hollow core of the membrane, whilst the retentate
15 nitrogen rich air remains on the outside of the membrane.

Because the gas separation system operates under low pressure, the separation process is energy efficient and the gas separation module that contains the hollow
20 fibre membrane can also be of a lightweight construction.

Incorporating a blanket of inert nitrogen rich air above a volatile or flammable liquid stored in a tank is an effective method of reducing the risk of flammable
25 vapour in the headspace of the tank being accidentally ignited. To inhibit ignition and combustion, the inert atmosphere above the flammable liquid needs to contain less than 13% oxygen, and preferably the inert atmosphere should contain between 10% and 12% oxygen,
30 i.e. an air composition of between 10% oxygen, 90% nitrogen and 12% oxygen, 88% nitrogen. If the nitrogen rich air contains less than 10% oxygen it would provide an extremely inert atmosphere.

A cost effective nitrogen inerting system could
35 have various end use applications, including the inerting of fuel tanks on board aircraft, fuel tanks on

board marine vessels, fuel tanks inside transport vehicles and large storage tanks used to contain bulk volumes of flammable or volatile materials. For example, fires and explosions inside aircraft fuel tanks are usually caused by an electrical source inside a fuel tank producing a spark that ignites the mixture of fuel vapour and air which has built up in the headspace of the tank. During refuelling, a static charge in the filling nozzle of the fuel tank can also ignite vapour that has been released from the aviation fuel. Although rare, the consequences of a fire or explosion in an aircraft fuel tank are invariably catastrophic.

Improvements in the safety of aircraft fuel tanks have tended to concentrate on minimising the ignition sources that can come into contact with the fuel vapour in the headspace of the fuel tank. However, aviation safety authorities have recently recognised that incorporating an inert atmosphere in the headspace of aircraft fuel tanks would also significantly reduce the risk of fire and explosion.

Fuel tanks and other storage tanks on board ships, warships and oil/gas platforms also provide a potential risk of fire and explosion, and again a nitrogen inerting system would provide a cost effective means of reducing this risk.

With regard to transport vehicles, static charges generated in the filling neck of a fuel tank during refuelling can ignite the vapour released from the more volatile conventional petroleum fuels, for example, such as petrol.

However, the flame is unable to propagate down the fill pipe into the fuel tank because the mixture of petrol vapour and air in the pipe is too rich, i.e. there is not enough oxygen in the mixture to support combustion. Consequently the risk of fuel tank fires

and explosions with conventional transport fuels is extremely low.

Alternative transport fuels are being developed as substitutes for conventional fuels, and some of these
5 are more volatile and flammable than their petroleum counterparts. There is therefore an increased risk that whilst filling the fuel tank with these particular fuels, the mixture of fuel vapour and air in the neck of the tank may accidentally ignite under normal
10 temperature conditions.

For example, E-Diesel, a blend of 15% natural ethanol and 85% diesel, has been developed as an alternative fuel for commercial transport vehicles. Because the natural ethanol constituent is manufactured
15 from renewable energy resources, E-Diesel has significant environmental benefits. Ethanol and diesel are immiscible and blending agents are used to form a mixture of the two materials.

The ethanol and the diesel in the blended fuel
20 retain their individual vapour pressures, and at normal ambient temperatures the headspace in the fuel tank is therefore mainly filled with the more volatile ethanol vapour. Unfortunately, the low flash point and greater flammability of the ethanol vapour increases the risk
25 that during refuelling a static charge could ignite the ethanol vapour present in the neck of the tank. Because of the stoichiometric concentration of the ethanol vapour under normal temperature conditions, the flame could then potentially travel down into the fuel tank
30 and cause a catastrophic failure.

UK Patent Application No. 0302211.8 describes a method of using the aforementioned hollow fibre membrane to produce nitrogen rich air on board aircraft for use as an inert atmosphere inside the fuel tanks of the
35 aircraft. The gas separation module described in this particular patent application was based on a traditional

design of module, where a very large number of individual membranes are cut to an appropriate size and they are then densely packed, in a substantially parallel manner, into the module. The individual
5 membranes are potted into polymer potting compound in the module, not only to hold the membranes in place inside the module but also to slightly separate the membranes from each other so that air can circulate around the outside of the membranes. This type of gas
10 separation module is therefore bulky and the large amount of potting compound required to hold the membranes in place adds to the weight of the module.

The present invention seeks to provide an improved gas separation module that uses the unique low pressure
15 properties of the permeable hollow fibre membrane in a manner whereby the module can be of a much more compact, as well as lightweight, construction. A compact and lightweight energy efficient nitrogen inerting system would be particularly advantageous for transport
20 applications, such as on board aircraft and inside vehicles, where weight and space are especially important.

From a first broad aspect, therefore, the present invention provides a gas separation module comprising a
25 plurality of strands of hollow fibre separation membrane arranged in an intertwined manner.

In a preferred embodiment the present invention provides an energy efficient gas separation system wherein a very long length of the permeable composite
30 hollow fibre membrane is wound around a hollow, preferably metal, support tube in a manner whereby the wound layers are closely packed together and are in direct contact with one another. The enmeshed and layered membrane structure can then be cut at each end
35 to form a bundle of closely intertwined stands of

membrane that can then be potted into a very compact and lightweight gas separation module.

The hollow fibre membrane would typically be at least 1 km in length and more probably the membrane
5 would be at least 1.5 km in length. It is important that the relatively long length of membrane is wound around the metal tube in a carefully controlled manner so as to avoid compression or constriction that could subsequently disrupt the flow of air through the hollow
10 core of the membrane. When the wound membrane is cut, a compact bundle of a very large number of closely intertwined individual membranes is formed. For example, there could be hundreds or even thousands of individual strands of membrane depending on the original
15 length of membrane that was wound onto the tube.

A light vacuum applied to the hollow core of the intertwined membranes draws air through the wall of the membranes and the air is selectively enriched with oxygen. The retentate air remaining on the outside of
20 the membranes becomes increasingly enriched with nitrogen as the retentate air slowly passes over the outside of the closely intertwined membranes located inside the gas separation module.

The oxygen rich air is drawn from the hollow core
25 of the membranes by the permeate vacuum pump. The retentate nitrogen rich air is drawn from the hollow core of the metal tube situated at the centre of the intertwined strands of membrane by either a very light vacuum or other light means of air displacement. The
30 flow rate of the permeate oxygen rich air from the membrane is much higher than the flow rate of the retentate nitrogen rich air. For example, typical flow rates for the permeate and retentate air streams might well be 30 litres/minute and 2 litres/minute
35 respectively.

The different flow rates of the permeate and retentate air streams also have an effect on the composition of the oxygen and nitrogen rich air fractions. For example, the permeate air from the gas separation module is only slightly enriched with oxygen and would typically contain about 22% oxygen, i. e. have a composition of 22% oxygen and 78% nitrogen. In contrast, the retentate air gradually becomes highly enriched with nitrogen as it passes over the membranes and would typically contain about 10% oxygen, i. e. a composition of 10% oxygen and 90% nitrogen, or even less, by the time the retentate air leaves the gas separation module.

Various embodiments of the gas separation module for the nitrogen inerting system will now be described, by way of example only, and with reference to the accompanying drawings in which:

Figure 1A is a schematic cross-sectional illustration showing the main components used in the construction of the gas separation module, Figure 1B shows the hollow fibre membrane after it has been completely wound around the hollow metal tube of the gas separation module and Figure 1C shows the membranes after they have been cut, potted and fixed into place inside the gas separation module.

Figures 2A and 2B illustrate internal end views of the two end caps used in the construction of the preferred embodiment.

Figure 3A is a side view showing the potted membranes partly covered by protective film. Figure 3B is a side view showing the completed gas separation module fitted with an external protective cover.

Figure 4 is a schematic illustration of the gas separation module connected to a vacuum pump.

Figure 5 is a schematic illustration of the preferred embodiment connected to a commercial fuel tank.

Figure 6 shows a graph of the oxygen content in the headspace of a fuel tank which is connected to the preferred embodiment against time.

Figure 7 is a schematic illustration of a preferred embodiment suitable for use in an aircraft flying at cruising altitude.

Figure 8 is a schematic illustration of a preferred embodiment suitable for use in an aircraft flying at various altitudes.

With reference to Figures 1 and 2, the main components of the gas separation module are a hollow metal tube 1, preferably made from a lightweight metal such as aluminium or aluminium alloy, and two metal end caps 2 and 3, which may also be made from lightweight metal. The metal tube 1 has a series of perforations 12 through the wall of the tube that allow air to pass through the wall of the metal tube into the hollow core of the tube. The perforations 12 may be situated near the end of tube 1 that will eventually be fixed to end cap 3 by means of locking nut 11, and this end of tube 1 is left open.

The opposite end of the metal tube 1 is fixed to a hollow metal fitment 7, which blocks off this end of tube 1. The fitment 7 has openings 13 that allow air to pass through the fitment 7. The free end of fitment 7 is left open and fitment 7 will eventually be fixed to end cap 2 by means of locking nut 6.

As shown in Figure 2A, end cap 2 may have a circular outer wall 4 and a circular inner wall 5 so that a recess is formed between the outer wall 4 and the inner wall 5. The enclosed space between the inner wall 5 of the end cap 2 and the outside of tube 1 forms a small reservoir for the polymer potting compound that

will eventually secure the open ends of the cut hollow fibre membranes in place inside the gas separation module.

5 In the preferred embodiment a circular hole 21 is provided at the centre of the base of cap 2, which allows the end of fitment 7 to protrude through cap 2 so that it can be locked in place by locking nut 6.

10 As shown in Figure 2B, end cap 3 may have a circular outer wall 8 and a circular inner wall 9 so that a recess is formed between the outer wall 8 and the inner wall 9. The recess is preferably perforated with a series of holes 10, which eventually allow atmospheric air to pass through end cap 3 into the gas separation module. The enclosed space between the inner wall 9 of
15 cap 3 and the outside of tube 1 forms a small reservoir for the polymer potting compound that will eventually hold the closed ends of the hollow fibre membranes in place inside the gas separation module.

20 There is a circular hole 22 at the centre of the base of cap 3, which allows the end of tube 1 to protrude through cap 3 so that it can be locked in place by locking nut 11.

A long length of membrane, i.e. a length of 1 km or more of membrane, is then wound around tube 1 in a
25 carefully controlled manner. The first layer of membrane is wound around tube 1 at an inclined angle, for example, of about 45° , with the membrane inclined from right to left. After the first layer has been wound onto tube 1, the second layer is wound over the
30 first layer at an angle of, for example, 45° , but with the membrane then inclined from left to right. The direction of the incline is then reversed on each subsequent layer until eventually the whole membrane has been wound onto tube 1 in a large number of reversed
35 layers. For example, there could be hundreds or even thousands of layers of membrane wound around tube 1,

preferably in a criss-cross fashion, depending on the original length of membrane.

This is illustrated schematically in Figure 1B, which shows the complete membrane wound onto tube 1.

5 The membranes of layers 14 are inclined at an angle from right to left, whilst the membranes of the lower layers 15 are inclined from left to right. The left hand end of the wound bundle of membranes is then completely cut through along a line marked from A on Figure 1B. This
10 exposes the open ends of the intertwined strands of membrane that have been formed from the large number of separate layers of membrane wound around tube 1.

As shown in Figure 1C, the exposed ends of the membranes are then potted into reservoir 17 in end cap 3
15 by potting compound 18, so that the ends are completely sealed and airtight, and tube 1 is fixed to end cap 3 by locking nut 11. The potting compound also helps to seal tube 1 to end cap 3. The right hand end of the wound bundle of membranes is then completely cut through along
20 a line marked from B on Figure 1B. This exposes the opposite open ends of the intertwined strands of membrane that have been wound onto tube 1. As shown in Figure 1C, the exposed ends of the membranes are then potted into reservoir 19 in end cap 2 by potting
25 compound in a manner whereby the ends of the membranes are open and lead to an evacuation chamber 20 formed inside cap 2. The end of fitment 7 is fixed to end cap 2 by locking nut 6, and the potting compound also helps to seal fitment 7 in place in cap 2. In fact, to
30 facilitate manufacture, the membranes may be potted into the potting compound first and the potted end then cut through to expose the fibre ends.

The method of manufacture described in relation to Figures 1B and 1C results in a structure with a very
35 large number of densely packed and intertwined membranes that can effect gas separation, i.e. structure 16 in

Figure 1C, which in turn allows the gas separation module containing the membranes to be of a very compact construction.

With reference to Figures 3A and 3B, the
5 intertwined membranes 16 (shown in Figure 1C), maybe loosely wrapped in a thin plastic protective film 23, except for a small portion of the membranes 24 adjacent to end cap 2 which is left exposed to air. A rigid
10 cylindrical protective outer cover 25, manufactured from either lightweight metal or a lightweight material, such as a composite or a plastic material, may then be fitted around the outside of end caps 2 and 3. An exit tube 26 is fitted to locking nut 6 to allow removal of the
15 permeate oxygen rich air from the gas separation module, and an exit tube 27 is fitted to locking nut 11 to allow removal of the retentate nitrogen rich air from the gas separation module.

Instead of using a single very long length of hollow fibre membrane in the construction of the gas
20 separation module, it is feasible that a number of shorter, albeit still relatively long lengths of membrane, could be used to produce the membrane strands that are used to effect gas separation inside the module. The membrane strands are preferably entwined.
25 For example, instead of using a single hollow fibre membrane 1 km long, it would be feasible to use say four shorter membranes each of 0.25 km in length, or five membranes each of 0.2 km in length, or ten membranes each of 0.1 km in length, or even a combination of
30 different lengths of membrane. The multiple lengths of membrane could be wound simultaneously or consecutively onto the hollow tube 1, preferably in a carefully controlled criss-cross manner, until the requisite length of membrane has been wound onto the tube.

35 The individual intertwined gas separation membranes would then be formed from the wound bundle by cutting

each end of the bundle and the membranes would be potted as described earlier. The gas separation module would then operate in much the same way as a module formed from a single long length of hollow fibre membrane.

5 The operation of the gas separation module will now be described with further reference to Figures 1A, 1B, 2A, 3A and 3B.

10 A light vacuum of about 0.5 bar applied to tube 26 draws air from the evacuation chamber 20. The vacuum then builds up in the hollow cores of the densely packed, intertwined membranes until eventually the atmospheric air on the outside of the membranes is drawn through the walls of the membranes and the air is selectively enriched with oxygen. The permeate oxygen
15 rich air is released to the outside atmosphere by tube 26.

20 Atmospheric air enters the gas separation module through the perforated holes 10 in end cap 3. As the vacuum builds up inside the hollow cores of the membranes, the atmospheric air is drawn into the exposed portion of the wound membranes 24, which may be close to end cap 2. The air then percolates under the protective film 23 and the air gradually passes over the outside of substantially all of the intertwined membranes.

25 As the air slowly washes over the outside of the membranes, it becomes increasingly enriched with nitrogen as permeate oxygen rich air is drawn through the walls of the membranes by the vacuum in the hollow cores of the membranes. Eventually the retentate
30 nitrogen rich air passes through the perforations 12 in metal tube 1 into the hollow core of the tube.

35 A very light vacuum of say less than 0.1 bar, or some other light means of air displacement, applied to the exit tube 27 draws the retentate nitrogen rich air out of the hollow core of tube 1. This light vacuum also encourages more atmospheric air to enter the gas

separation module through the perforations 10 in end cap 3 and wash across the outside of the intertwined membranes.

5 The retentate air leaving the module through the exit tube 27 is rich enough in nitrogen to be used directly as an inert atmosphere inside fuel tanks. Typically the permeate oxygen rich air leaving the module in tube 26 would consist of 22% oxygen, 78% nitrogen, and the retentate nitrogen rich air leaving 10 the module in tube 27 would consist of about 10% oxygen, 90% nitrogen.

The volume and the composition of the retentate nitrogen rich air can be varied in a number of ways including, for example, by altering the gas separation 15 properties of the hollow fibre membrane; by changing the length of hollow fibre membrane packed into the module; and by altering the relative pressures and flow rates of the permeate and retentate air streams.

The throughput of nitrogen rich air can also be 20 increased by operating a multiplicity of gas separation modules together in parallel.

Alternative nitrogen inerting systems, based on the principles described above, have been developed for different end-use applications, and some typical 25 examples are described below.

Example 1

The first example is a relatively simple application involving the supply of an inert atmosphere 30 to the fuel tank of a prototype racing sports car fuelled by natural ethanol. The flammability and volatility of the ethanol fuel poses a fire risk during refuelling under race conditions, and a nitrogen inerting system was therefore developed for the racing 35 car. The inerting system is described with reference to Figure 4.

A 1.5 km length of composite hollow fibre membrane, produced by the method disclosed in UK Patent Application No. 0301139.2, and in the form of a multitude of intertwined strands of membrane, is
5 contained inside the gas separation module 25. Exit tube 26 is connected to a vacuum pump 28 so that the hollow cores of the intertwined membranes can be subjected to a vacuum of about 0.5 bar. The vacuum pump draws permeate oxygen rich air 29 from the gas
10 separation module at a rate of about 30 litres/minute.

In this particular application, under racing conditions the sports car has high fuel consumption and the ethanol fuel is used at an average rate of about 3 litres/minute. The fuel level therefore falls quickly
15 inside the fuel tank and the resulting pressure drop in the tank is sufficient to draw the retentate nitrogen rich air 30 directly from the gas separation module 25 into the fuel tank, without the assistance of an additional air displacement pump. Under these
20 particular operating conditions, the nitrogen rich air 30 from the gas separation module 25 would contain about 11% oxygen, i.e. the inert air would have a typical composition of 11% oxygen, 89% nitrogen. The exit tube 27 containing the nitrogen rich air 30 may be connected
25 directly into the mouth of the fuel tank inside the racing car.

As the fuel level drops, inert nitrogen rich air 30 is automatically sucked from the gas separation module 25 into the fuel tank, whilst the permeate oxygen rich
30 air 29 from the vacuum pump 28 is released into the outside atmosphere.

The inert nitrogen rich air 30 accumulates in the mouth and the filling neck of the fuel tank, and builds up in the headspace of the fuel tank. The inert
35 nitrogen rich atmosphere in the mouth of the tank helps

to reduce the risk of a static charge accidentally igniting ethanol vapour during refuelling.

5 Even if the ethanol vapour in the mouth of the tank did ignite, the inert atmosphere in the filling neck of the fuel tank would prevent the flame propagating down into the fuel tank. An inert atmosphere in the fuel tank is also an additional safety feature in the event of the sports car suffering either an accident or impact damage during racing.

10 The properties of the nitrogen inerting system developed for the motor racing sports car are summarised in Table 1.

Table 1
Nitrogen Inerting System

15 For a Racing Sports Car Fuelled by Natural Ethanol

Property	Value
Length of hollow fibre membrane	1.5 km
Diameter of the gas separation module	10 cm
Length of the gas separation module	38 cm
Volume of the gas separation module	3 litres
Weight of the gas separation module	< 1.5 kg
Sports car fuel consumption	180 litres/hour
Flow of nitrogen rich air into fuel tank	3 litres/minute
Typical composition of nitrogen rich air	11% oxygen, 89% nitrogen
Vacuum on permeate air stream	Approx. 0.5 bar
Flow of oxygen rich air to atmosphere	30 litres/minute

Example 2

Figure 5 illustrates a nitrogen inerting system developed for commercial transport vehicles that would be fuelled by a volatile fuel such as the E-Diesel blend of ethanol and diesel.

5 There are significant performance differences between commercial transport vehicles and the motor racing sports car described in Example 1. For example, a typical commercial transport vehicle probably has an average fuel consumption of between 10 and 20
10 litres/hour, whereas the motor racing car has a fuel consumption of about 180 litres/hour.

With reference to Figure 5, a vacuum pump 28 draws the oxygen rich air 29 from the gas separation module 25 through exit pipe 26 and the oxygen rich air 29 is
15 released into the atmosphere. The fuel consumption of a normal commercial transport vehicle would be insufficient to create a differential pressure in the fuel tank 32 that would be reliable enough to draw the inert nitrogen rich air 30 from the gas separation
20 module 25 into the tank. A light vacuum pump 31 is therefore used to displace the nitrogen rich air 30 from the gas separation module 25 into the fuel tank 32.

Figure 5 illustrates a typical commercial fuel tank 32, which has a filling neck 34 leading to a filling
25 pipe 33 connected to the fuel tank 32. The filling neck 34 is sealed by a filling cap 36. The light pump 31 feeds the nitrogen rich air 30 into the mouth 35 of the filling neck 34 and the inert air 30 then gradually percolates down the filling pipe 33 into the headspace
30 of the fuel tank 32.

As the inert nitrogen rich air 30 accumulates in the mouth 35, the filling neck 34, the filling pipe 33 and the headspace of the fuel tank 32, the atmosphere becomes increasingly more inert. It is therefore
35 extremely unlikely that a static charge generated in the mouth 35 of the filling neck 34 during refuelling would

be able to ignite any ethanol vapour present in the mouth of the fuel tank. Even if the ethanol vapour did ignite, the inert atmosphere in the filling neck 34 and the filling pipe 33 would inhibit combustion and the flame would not be able to spread down into the fuel tank 32.

The fuel tank may be fitted with a venting pipe 37 that allows any excessive build-up of fuel vapour 39 in the headspace of the tank 32 during relatively warm conditions to be vented either to the outside atmosphere or to the air intake of the engine. The venting process is controlled by a pressure relief valve 38. The pressure of the nitrogen rich air 30 supplied into the fuel tank 32 by pump 31 would not, on its own, be high enough to activate the pressure relief valve 38.

Venting systems vary between different fuel tanks. For example, some tanks vent fuel vapour back into the mouth of the fuel tank, and a pressure relief filling cap is used to allow excessive build-up of vapour to be released into the atmosphere. The nitrogen inerting system described in Figure 5 should be able to work satisfactorily with any of the normal methods employed to vent fuel tanks.

The nitrogen inerting system was tested under simulated conditions by using a 200 litre fuel tank 32 filled with E-Diesel fuel. Initially, the headspace over the fuel in the tank 32 was filled with normal atmospheric air, i.e. air with a composition of 21% oxygen, 79% nitrogen. The flow of fuel from the tank 32 was set at a constant flow rate of 20 litres/hour, and the flow of nitrogen rich air 30 from the gas separation module 25 into the tank 32 was controlled at 1.5 litres/minute. The oxygen content of the air in the headspace of the fuel tank 32 was measured at regular intervals.

As shown by the graph in Figure 6, under the above test conditions an inert atmosphere, i.e. air containing less than 13% oxygen, was achieved in the headspace of the fuel tank 32 in less than 40 minutes and after 60 minutes the inert air in the headspace of the tank 32 contained only 11.5% oxygen. The air in the headspace then gradually became increasingly more inert until after 5 hours running, by which time the tank was only half full of fuel, the air was extremely inert and contained only 7% oxygen, i.e. an air composition of 7% oxygen, 93% nitrogen.

At an oxygen concentration of 7%, the very inert atmosphere inside the fuel tank 32 would also help to reduce the risk of fire in the event of either an accident or an impact that damaged or ruptured the fuel tank 32.

Because nitrogen rich air 30 is continually fed into the fuel tank 32 by the nitrogen inerting system whenever the engine of the vehicle is running, an inert atmosphere is always maintained in the filling neck and in the headspace of the fuel tank. When the vehicle is parked and the engine is not running, most fuel tanks are airtight enough to be able to retain the inert atmosphere inside the tank for an appreciable length of time.

The properties of the commercial transport vehicle nitrogen inerting system, as tested in the laboratory, are summarised in Table 2.

30

Table 2

Nitrogen Inerting System

For a Commercial Transport Vehicle Fuelled by E-Diesel

Property	Value
Length of hollow fibre membrane	1.5 km

Diameter of the gas separation module	10 cm
Length of the gas separation module	38 cm
Volume of the gas separation module	3 litres
Weight of the gas separation module	< 1.5 kg
Tested fuel consumption	20 litres/hour
Vacuum on retentate air stream	Less than 0.1 bar
Flow of nitrogen rich air	1.5 litres/minute
Composition of nitrogen rich air	Down to 7% oxygen, 93% nitrogen
Vacuum on permeate air stream	Approx. 0.8 bar
Flow of oxygen rich air	30 litres/minute

Example 3

Large passenger aircraft fly at high altitudes, typically a height of about 11000 metres, in order to conserve fuel and achieve an adequate flight range. Although the atmospheric air composition remains the same irrespective of altitude, i.e. 21% oxygen, 79% nitrogen, the atmospheric pressure decreases as altitude increases, as illustrated in Table 3.

A reduction in atmospheric pressure is accompanied by a decrease in the ability of humans to transfer oxygen from the lungs to the bloodstream, an effect known as hypoxia. To protect passengers and crew from hypoxia, passenger aircraft flying above 3000 metres are therefore pressurised to compensate for the reduced atmospheric pressure.

Table 3

Ambient Pressure at Different Altitudes

Altitude	Altitude	Ambient Pressure	Ambient Pressure
----------	----------	------------------	------------------

(Feet)	(Metres)	(KPa)	(PSI)
0	0	101.4	14.7
4750	1448	84.0	12.19
8000	2438	76.7	10.83
10000	3048	72.0	10.44
12000	3658	64.0	9.28
15000	4572	57.4	8.35
17500	5334	50.7	7.35
25000	7620	38.6	5.6
36000	10973	22.7	3.29
40000	12192	18.7	2.71
44000	13411	16.0	2.32
60000	18288	7.3	1.06

To allow an aircraft to be pressurised, the fuselage has to be strengthened so that the fuselage can act as a pressure vessel. However, strengthening the fuselage has a detrimental impact on the fuel consumption and hence the potential range of the aircraft. The cabin pressure is therefore usually maintained at about 10.83 psi (74.7 kPa), which is equivalent to the atmospheric pressure at an altitude of about 2400 metres, to reduce the amount of strengthening required to the airframe.

Figures 7 and 8 illustrate two alternative nitrogen inerting systems that could be used on board passenger aircraft to provide an inert atmosphere in the fuel tanks of the aircrafts.

Figure 7 illustrates a relatively simple nitrogen inerting system, which utilises the differential pressure that is naturally available when a passenger aircraft is flying at its cruising altitude, i.e. the pressure differential between the cabin pressure inside the aircraft and the atmospheric pressure outside the aircraft.

The gas separation module 40, which would include a very large number of individual intertwined hollow fibre membranes, would be located in the air conditioning system that supplies pressurised air to the passenger cabins of the aircraft. Up to 22 m³/hour of inert nitrogen rich air 46 would need to be delivered to the fuel tanks of the aircraft to replace the fuel being burned by the aircraft when it is flying at its normal cruising altitude.

Although a single gas separation module 40 is illustrated in Figure 7, in practice a multiplicity of modules, operating together in parallel, would be needed to produce this amount of inert air 46.

The air transport regulatory authorities specify that each passenger on an aircraft should be supplied with about 10 ft³/min (0.28 m³/min) of fresh air. On large passenger aircraft, which can carry up to 550 passengers plus crew, this amount of fresh air per passenger is equivalent to a total air supply of about 165 m³/minute or 9900 m³/hour. The amount of pressurised cabin air required to produce 22 m³/hour of inert nitrogen rich air is therefore virtually insignificant compared to the total amount of fresh air supplied to the passenger cabins of an aircraft.

In the simple nitrogen inerting system illustrated in Figure 7, the gas separation module 40 is operated by means of the differential pressure that exists between the inside and the outside of an aircraft flying at its cruising altitude, and no additional pumps are required in the system. For example, in an aircraft cruising at a height of 11000 metres the cabin pressure is 10.83 psi (74.7 kPa) whilst the atmospheric pressure outside the aircraft is 3.29 psi (26.9 kPa), and the resulting pressure differential of 7.54 psi (52.0 kPa) would be sufficient to operate the gas separation module 40.

In Figure 7, an exit pipe 42, which takes the permeate oxygen rich air 43 from the module 40, would be connected to an outlet valve positioned in the airframe at the rear of the aircraft that would lead directly to the outside atmosphere. Passenger aircraft are already fitted with a valved outflow air system that continually discharges stale air from the passenger cabins into the outside atmosphere. The outlet valve for the reject permeate air from the gas separation module 40 could therefore be an integral part of the existing outflow air system of the aircraft.

Opening the outlet valve would create a pressure differential between the pressurised cabin air 41 being fed into the module 40, which would be at a pressure of 10.83 psi (74.7 kPa), and the atmospheric air on the outside of the aircraft, which would be at 3.29 psi (26.9 kPa). This drop in pressure would be sufficient to pull the cabin air 41 through the walls of the hollow fibre membranes and selectively enrich the air with oxygen. The low pressure outside the aircraft would then draw the reject permeate oxygen rich air 43 from module 40 into the outside atmosphere. Because the fuel tanks in an aircraft are not pressurised, the exit pipe 45 that takes the nitrogen rich air 46 from the module 40 would be connected to a valve 44, which would bleed the inert nitrogen rich air 46 into the fuel tanks at the required pressure and flow rate.

The simple nitrogen inerting system illustrated in Figure 7 is particularly suitable for the 'steady-state' conditions that exist whilst an aircraft is flying at its cruising altitude, i.e. where the atmospheric pressures inside and outside the aircraft are reasonably constant. However, during a flight, different and variable pressure conditions exist when an aircraft is ascending during takeoff and descending on landing. When the aircraft is on the ground the pressure inside

and outside the aircraft is of course at normal ambient ground level conditions.

On landing, the fuel tanks of the aircraft would still contain the nitrogen rich atmosphere that had been supplied by the nitrogen inerting system during the flight. However, the refuelling process on the ground is always a risky operation because a static charge could ignite aviation fuel vapour present in the filling nozzles of the fuel tanks and cause a fire. A continual supply of nitrogen rich air from the nitrogen inerting system to the filling nozzle and the headspace in the fuel tanks whilst the aircraft was being refuelled on the ground would therefore be an additional safety feature.

Figure 8 illustrates modifications to the aircraft nitrogen inerting system that would allow the system to be used under different operating conditions. For example, the air 41 entering the gas separation module 40 would be at normal ambient atmospheric pressure, i.e. 14.7 psi (101.4 kPa), when the aircraft is on the ground and at about 10.83 psi (74.7 kPa) when the aircraft reaches its cruising altitude. To cater for differing pressure conditions the exit tube 42 that takes the permeate air 43 from the gas separation module 40 is connected to a valve 47, and at cruising altitude valve 47 allows the permeate air 43 to be passed directly to the outlet valve of the aircraft.

During ascent, descent and whilst the aircraft is on the ground, when the cabin pressure is either at or near ambient atmospheric conditions, valve 47 would divert the permeate air stream to a light vacuum pump 48. The vacuum pump would then create a pressure drop in the hollow cores of the membranes in order to facilitate the gas separation process and the reject permeate air 49 from the vacuum pump 48 would be

released through the outlet valve to the outside atmosphere.

Exit tube 45 that takes the retentate nitrogen rich air from the module 40 is still connected to valve 44.

5 At cruising altitude, valve 44 would bleed the inert nitrogen rich air 46 into the fuel tanks at the required pressure and flow rate. However, during ascent, descent and whilst the aircraft is on the ground, when the cabin pressure is either at or near ambient atmospheric
10 conditions, valve 44 diverts the retentate air to a very light pump 50, which positively displaces the inert nitrogen rich air 51 to the fuel tanks of the aircraft.

The vacuum pumps 48 and 50 are also able to control the relative flows of the permeate air and the retentate
15 air streams respectively. As such, the system is able to deliver the appropriate amount of inert nitrogen rich air at the required composition to suit particular operating conditions, i.e. depending on whether the aircraft was being refuelled on the ground, or if the
20 aircraft was in takeoff, landing or cruising mode.

The examples described show how the nitrogen inerting system would be able to provide an inert atmosphere in the headspace of tanks or vessels containing volatile or flammable materials, such as
25 fuels, solvents and chemicals. Because the nitrogen inerting system is a low pressure system it is safe to use and there is very little risk of a pressure blow out that could damage individual gas separation membranes, or cause damage to either the gas separation module or
30 its immediate surroundings.

A further advantage of the inerting system is that the permeate oxygen rich air from the gas separation module is only very slightly enriched with oxygen, i.
e. 22% oxygen instead of the 21% oxygen in normal air.
35 Unlike pure oxygen or air highly enriched with oxygen, both of which can encourage spontaneous combustion, if

any permeate oxygen rich air did escape from the gas separating module it would neither encourage combustion nor pose a safety risk.

5 As shown in the examples, the nitrogen inerting system would be particularly beneficial for fuel tanks used in transport applications, such as in vehicles, ships and aircraft. An inert atmosphere in the filling neck and the headspace of a fuel tank significantly reduces the risk of a static charge accidentally
10 igniting fuel vapours in the mouth of the tank during refuelling. Even if the fuel vapour did ignite the inert nitrogen rich atmosphere in the filling neck of the tank would not support combustion and the flame would not be able to spread down into the fuel tank.

15 An inert atmosphere in the headspace of a fuel tank also reduces the risk of immediate fire or explosion in the event of a fuel tank being accidentally punctured or ruptured. By way of example, an inert atmosphere in the fuel tanks of military vehicles, ships and aircraft
20 would help to reduce the risk of immediate fire or explosion if the fuel tank was, for example, punctured or damaged by shrapnel during battle conditions.

Bulk storage tanks for fuels, solvents and chemicals could also benefit from a nitrogen inerting
25 system, particularly storage facilities that may be vulnerable to either man made disasters, such as potential war zones, natural disasters, such as earthquakes, or terrorist attack.

Examples of more specialised applications for a
30 nitrogen inerting system could well include the storage of chemicals and materials that spontaneously ignite, react, oxidise, degrade or change in nature if they are stored in normal atmospheric air, as well as storage applications where a low oxygen, anti-corrosive
35 atmosphere would be beneficial.

Although the present invention has been described with reference to the preferred embodiments, it will be understood by those skilled in the art that various changes in form and detail may be made without departing
5 from the scope of the invention as set forth in the accompanying claims.

CLAIMS:

- 5 1. A gas separation module comprising:
a plurality of strands of hollow fibre separation
membrane arranged in an intertwined manner, preferably
around a core.
- 10 2. A gas separation module comprising:
a plurality of strands of hollow fibre separation
membrane wound around a core, preferably in a criss-
cross fashion.
- 15 3. A module as claimed in claim 1 or 2, wherein said
module comprises two or more layers of membrane wound
around said core.
- 20 4. A module as claimed in claim 3, wherein the strands
of membrane in adjacent layers are wound around said
core in different directions and/or at different angles,
preferably such that the strands of membrane in adjacent
layers are in contact with each other.
- 25 5. A module as claimed in claim 4, wherein adjacent
layers are wound in opposite directions.
- 30 6. A module as claimed in any preceding claim, wherein
said strands of membrane are wound around said core so
as to remain substantially free from compression or
constriction.
- 35 7. A module as claimed in any preceding claim, wherein
the strands of membrane are produced by winding one or
more lengths of membrane onto said core and then cutting
through the bundle of wound membrane(s) at each end to

produce a plurality of entwined strands of membrane wound around said core.

8. A module as claimed in claim 7, wherein a first end
5 of each membrane strand is sealed so as to be air tight.

9. A module as claimed in claim 8, wherein said end of each strand is potted into polymer potting compound to seal it.

10

10. A module as claimed in claim 8 or 9, wherein the sealed end of the plurality of strands of membrane is fixed into a first end cap.

15 11. A module as claimed in claim 10, wherein said cap has one or more holes for admitting air to a first of said membrane fibres.

20 12. A module as claimed in any of claims 7 to 11, wherein the second end of each membrane strand is left open.

25 13. A module as claimed in claim 12, wherein the said second end of each membrane strand is potted into polymer potting compound and the potting compound is then cut to expose a new open end on each strand of membrane.

30 14. A module as claimed in claim 13, wherein the open end of the plurality of strands of membrane is fixed into a second end cap.

35 15. A module as claimed in claim 14, wherein the second end cap provides an evacuation chamber.

16. A module as claimed in any of any preceding claim, wherein said core is a hollow tube having one or more openings for removal or supply of air to the module.

5 17. A module as claimed in claim 16, wherein at least some of said openings in said hollow tube are located adjacent a first and/or second end cap.

10 18. A module as claimed in any preceding claim, wherein one enriched gas outlet is provided at an end of the module opposite the air inlet thereto.

15 19. A module as claimed in any preceding claim, wherein said plurality of strands of membrane are provided with an impermeable cover.

20 20. A module as claimed in claim 19 as dependent directly or indirectly upon claims 10 and 14 wherein said cover extends from said first cap to a position spaced from said second cap whereby air is admitted to the membrane through the spacing between the cover and the second cap.

25 21. A module as claimed in any of claims 15 to 20 as dependent directly or indirectly upon claims 10 and 14 wherein a protective cover extends between the first and second caps.

30 22. A module as claimed in any preceding claim, wherein said membrane comprises a polyethersulfone polymer fibre tube coated on the outside with a thin coating of a selective polymer consisting of a mixture of cross-linked and non-cross-linked polydimethylsiloxane.

35 23. A module as claimed in claim 22, wherein said polyethersulfone fibre tube component of the hollow

membrane has been subjected to a modification technique, involving repeatedly soaking the tube in acetone solution, displacing the acetone solution with distilled water and then drying the tube so that it has increased
5 gas permeability properties.

24. An air separation system comprising: an air separation module as claimed in any preceding claim; means to draw air into the module; means to draw oxygen
10 rich air from one side of the membranes in the module; and means to draw nitrogen rich air from the other side of the membranes in the module.

25. A system as claimed in claim 24, wherein said means
15 for drawing air into the module and drawing oxygen rich air from the system comprises a pump.

26. A system as claimed in claim 24 or 25, wherein said means for drawing nitrogen rich air from said module
20 comprises a pump.

27. A fuel system comprising a fuel tank and a system as claimed in claim 24, 25 or 26 for supplying nitrogen rich air to the fuel tank.
25

28. An inert atmosphere system comprising a system as claimed in claim 24, 25 or 26 in fluid communication with a space requiring an inert atmosphere.

30 29. A method of producing nitrogen enriched air comprising separating normal air into a nitrogen enriched fraction and an oxygen enriched fraction by means of passing air over a plurality of strands of hollow fibre separation membrane entwined around a core.
35

30. A method as claimed in claim 29 comprising withdrawing permeate oxygen enriched air from the hollow cores of said strands of membrane at a first rate; and withdrawing retentate nitrogen enriched air from around
5 the membranes at a second, lower, rate.

31. A method of producing nitrogen enriched air comprising separating normal air into a nitrogen enriched fraction and an oxygen enriched fraction by
10 means of passing air through the strands of hollow fibre separation membrane of apparatus as claimed in any of claims 1 to 24.

32. A method as claimed in claim 29, 30 or 31, wherein
15 a pressure differential is applied between the outside and inside of the strands of membrane, preferably the hollow cores of said strands of membrane being maintained at a pressure which is lower than the pressure on the outside of the strands of membrane.

20 33. A method as claimed in claim 32, wherein if the pressure on the outside of the strands of membrane is equivalent to normal, sea-level atmospheric pressure then the pressure in said hollow cores is between 0.5
25 and 0.8 bar (between 50 kPa and 20 kPa).

34. A method as claimed in any of claims 29 to 33, wherein said retentate nitrogen rich air is supplied to a tank or vessel by applying a slight vacuum of no more
30 than 0.1 bar (10 kPa) to the retentate air stream.

35. A method as claimed in any of claims 29 to 34, wherein said retentate air comprises between 10% oxygen, 90% nitrogen and 12% oxygen, 88% nitrogen.

35

36. A method as claimed in any of claims 29 to 35, wherein said retentate air comprises less than 10% oxygen.

5 37. A method as claimed in any of claims 29 to 36, wherein said retentate air comprises 7% oxygen and 93% nitrogen.

10 38. A method as claimed in any of claims 29 to 37, wherein either the volume and/or the composition of the retentate nitrogen rich air is varied by changing either the total length and/or gas separation properties of the hollow fibre membrane.

15 39. A method as claimed in any of claims 29 to 38, wherein either the volume and/or the composition of the retentate nitrogen rich air is varied by changing the relative pressures and/or flow rates of the retentate and permeate air streams drawn from the module.

20 40. A method of manufacturing a gas separation module comprising; winding one or more length of hollow gas separation membrane around a core and cutting through the membrane at each end to produce a plurality of
25 individual membrane lengths.

41. A method of manufacturing a gas separation module as claimed in claim 40, said method comprising winding a single long length or a number of shorter lengths of
30 hollow fibre membrane around a metal tube in layers in a criss-cross fashion, cutting each end of the bundle of wound membrane(s) to produce a plurality of individual entwined strands of membrane surrounding said metal tube, potting the strands of membrane in potting
35 compound so that at one end the membrane strands are

sealed airtight whilst at the opposite end the membrane strands are open.

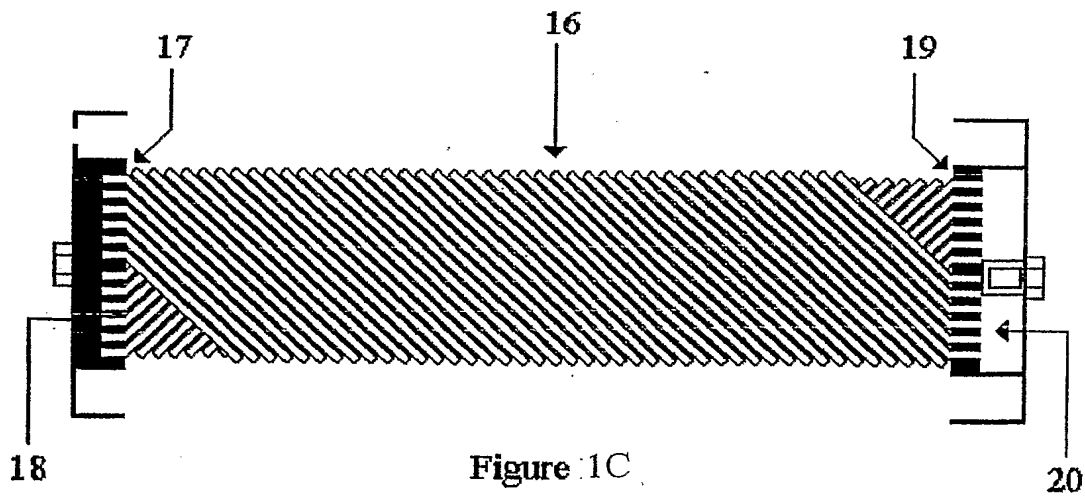
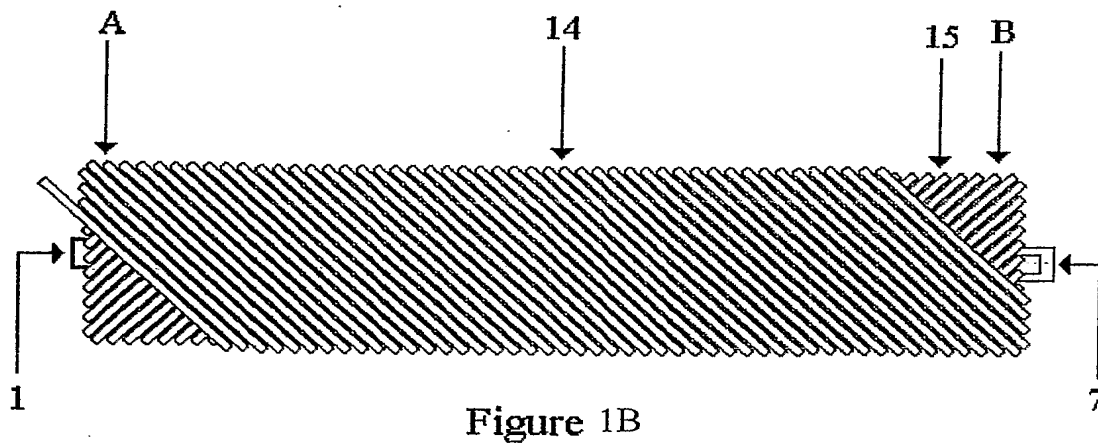
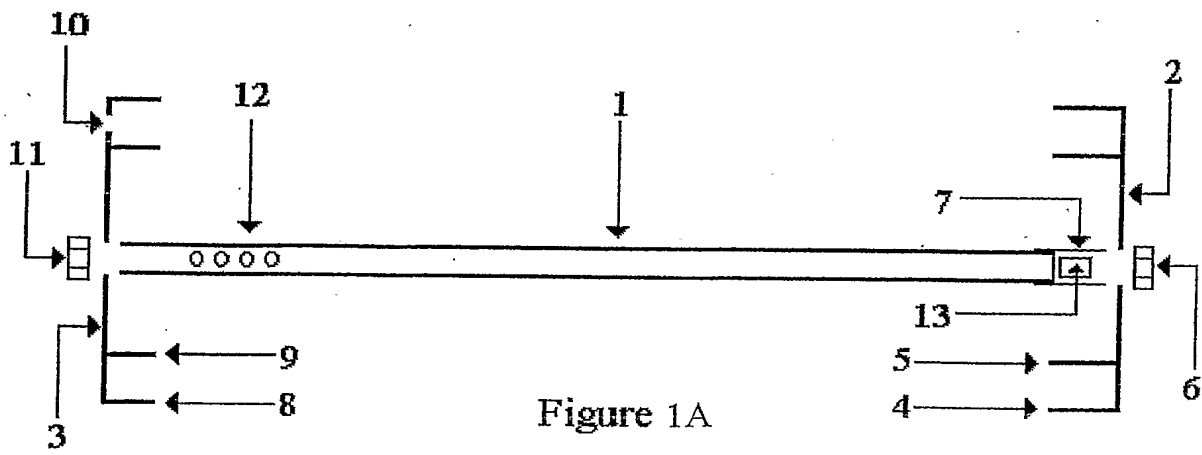
42. A method as claimed in claim 40 or 41, wherein the
5 total length of membrane used to form the plurality of membrane stands is between 1 km and 1.5 km or more.

43. A method as claimed in claim 40, 41 or 42, wherein
a number of lengths of membrane are simultaneously or
10 consecutively wound around said core or metal tube.

44. A gas separation module comprising:
a plurality of strands of hollow fibre separation
membrane;
15 means for releasing at a first rate permeate oxygen enriched air from the hollow cores of said strands of membrane to the outside of said module; and
means for releasing retentate nitrogen enriched air
from module at a second rate;
20 wherein said first rate is greater than said second rate.

45. A gas separation module as claimed in claim 44,
further comprising means for providing a pressure
25 differential between the outside and the inside of said strands of membrane.





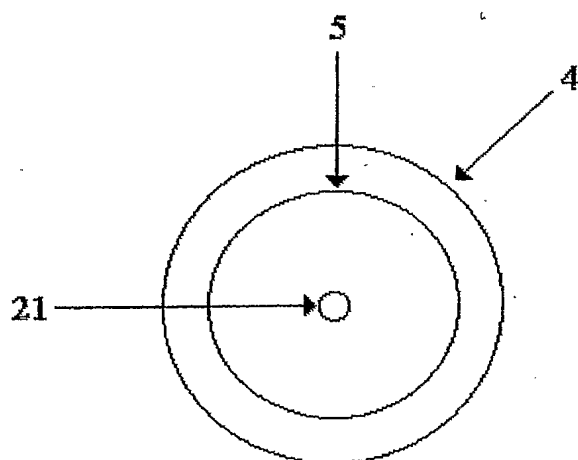
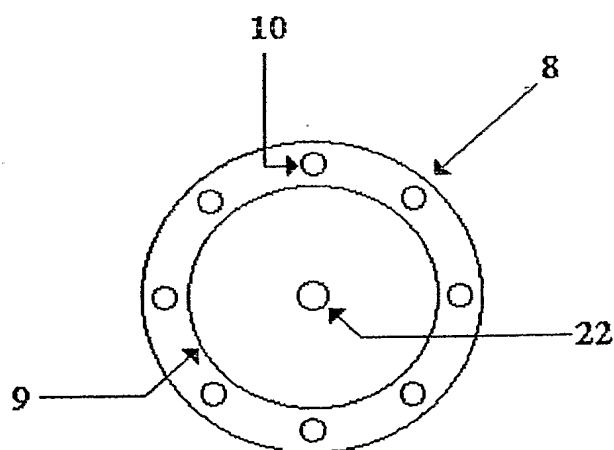


Figure 2A



End Cap 3

End Caps - Internal End View

Figure 2B

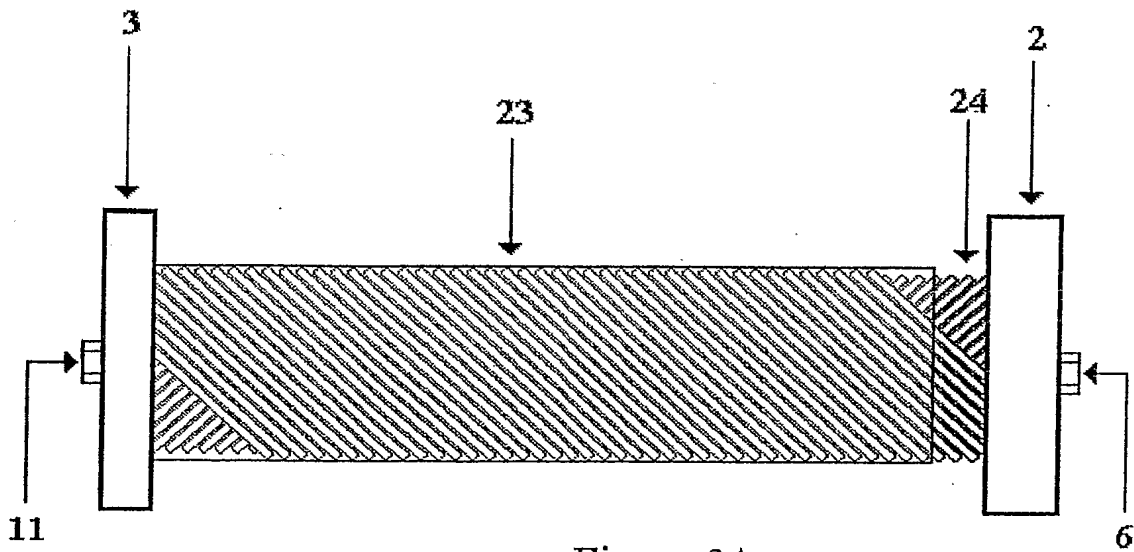


Figure 3A

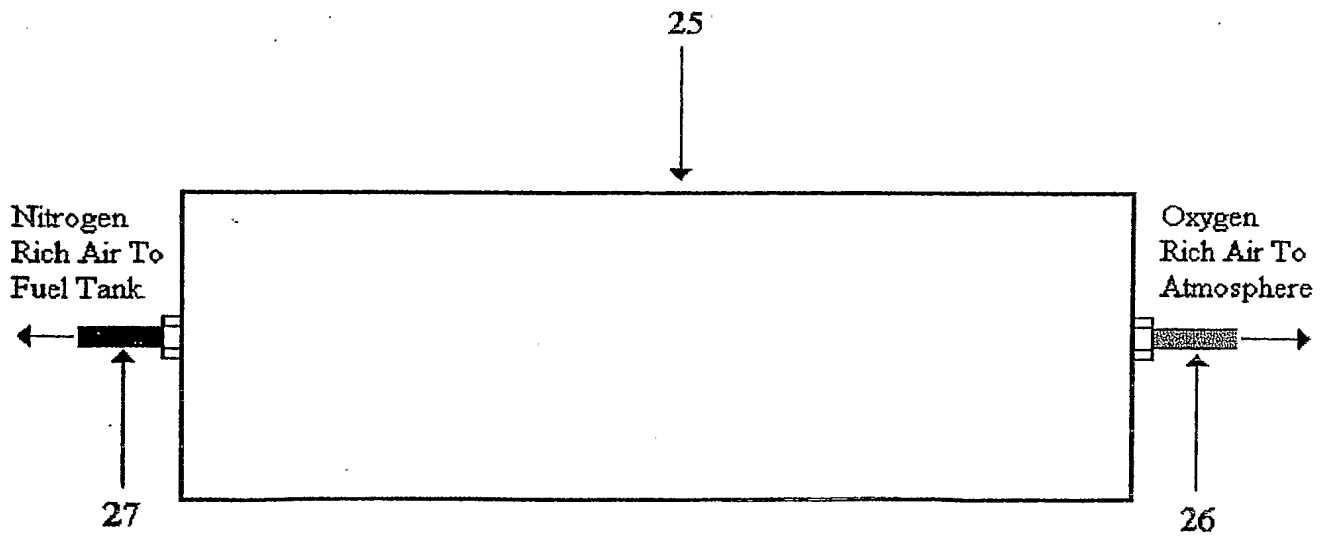


Figure 3B



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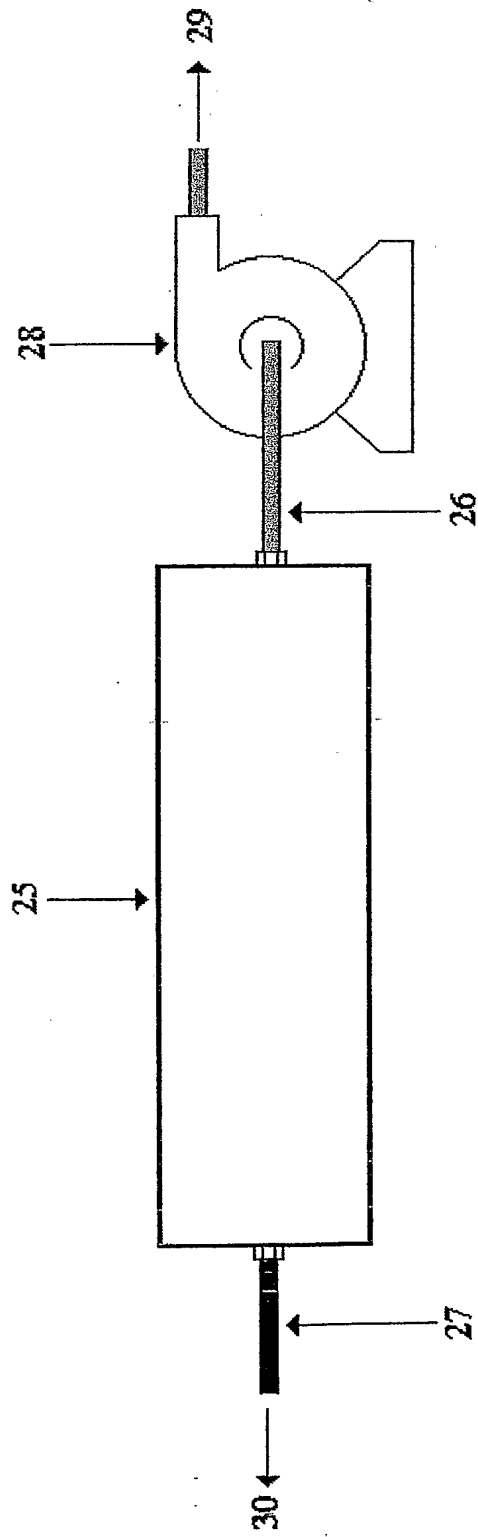
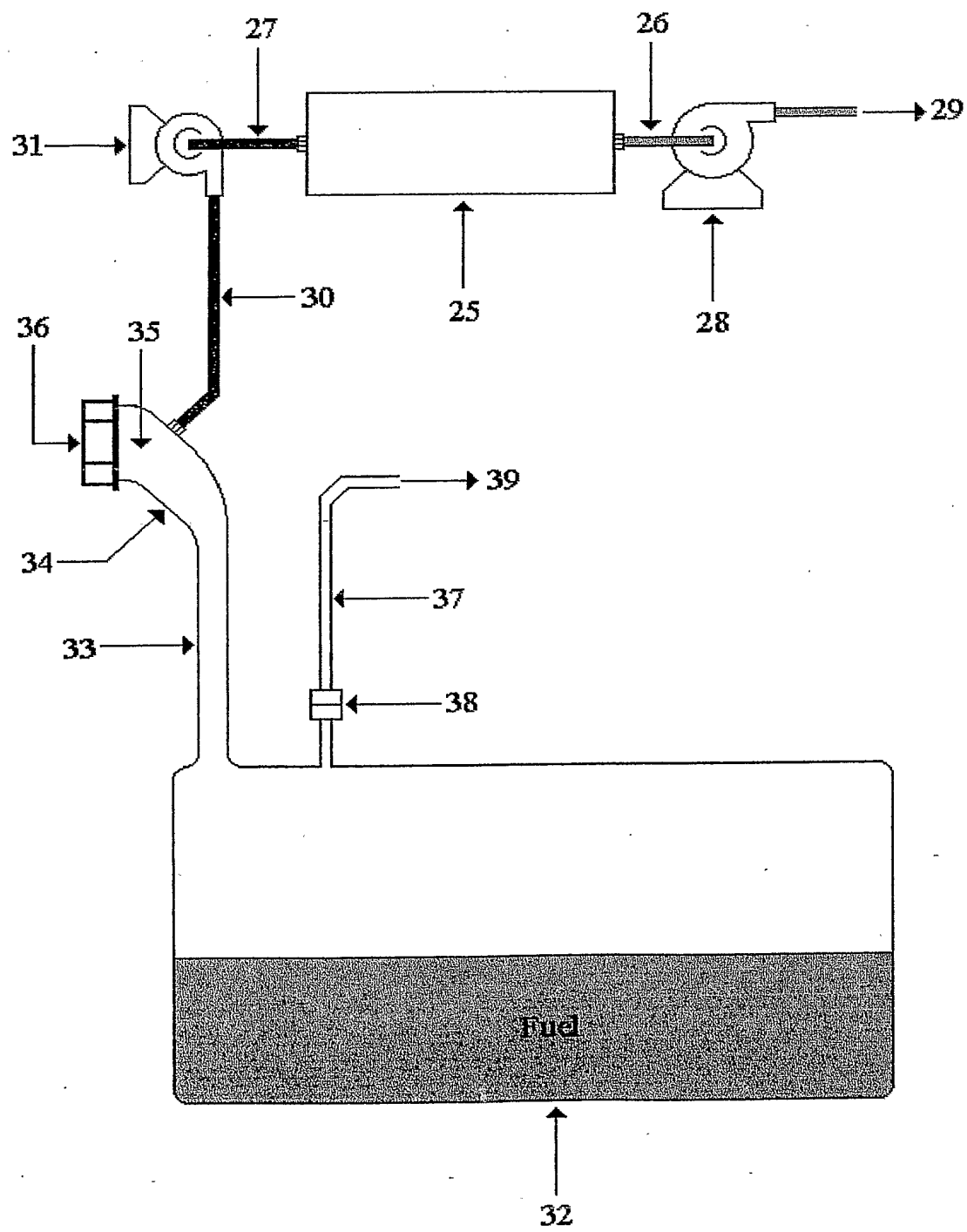


Figure 4

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Figure 5





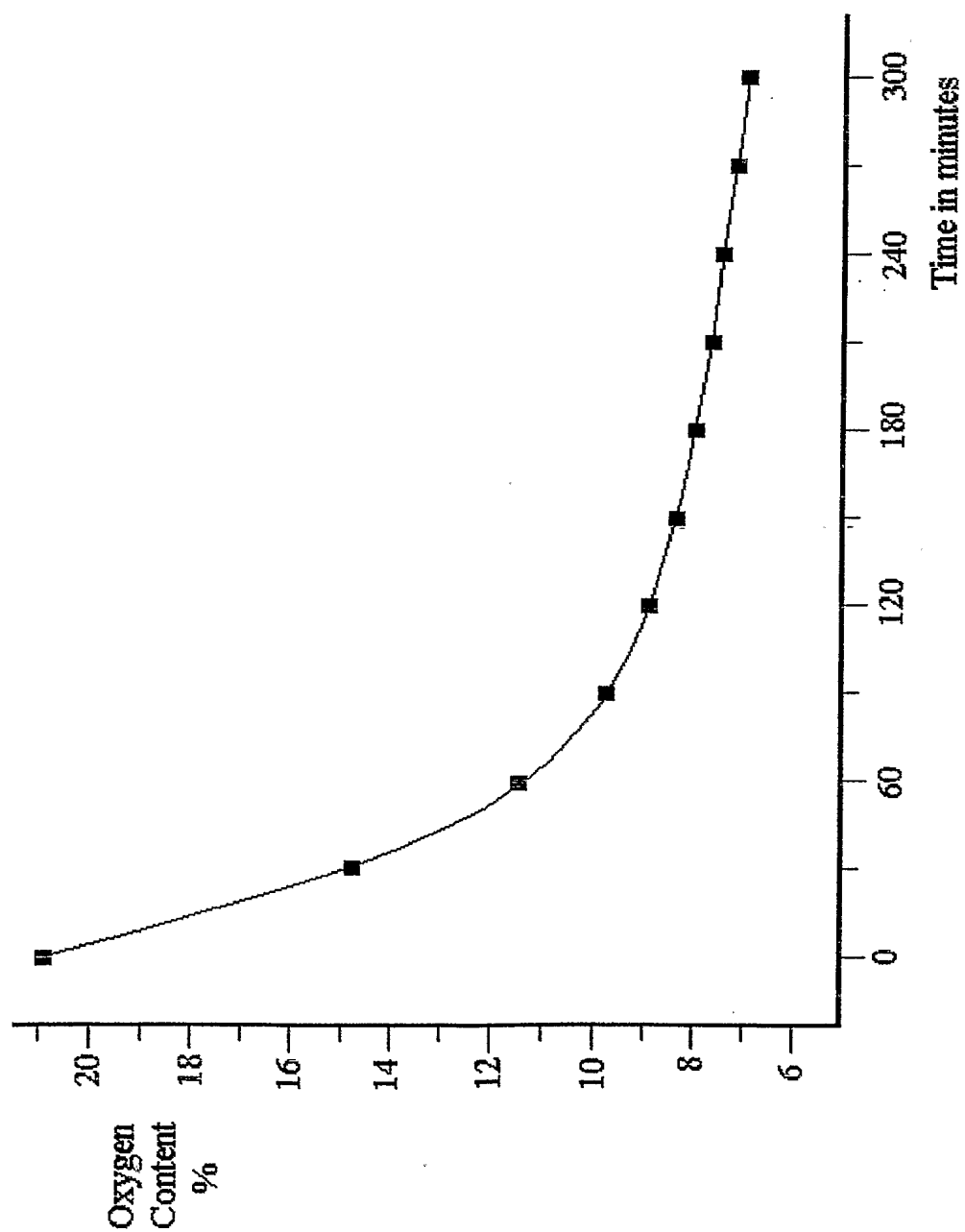


Figure 6



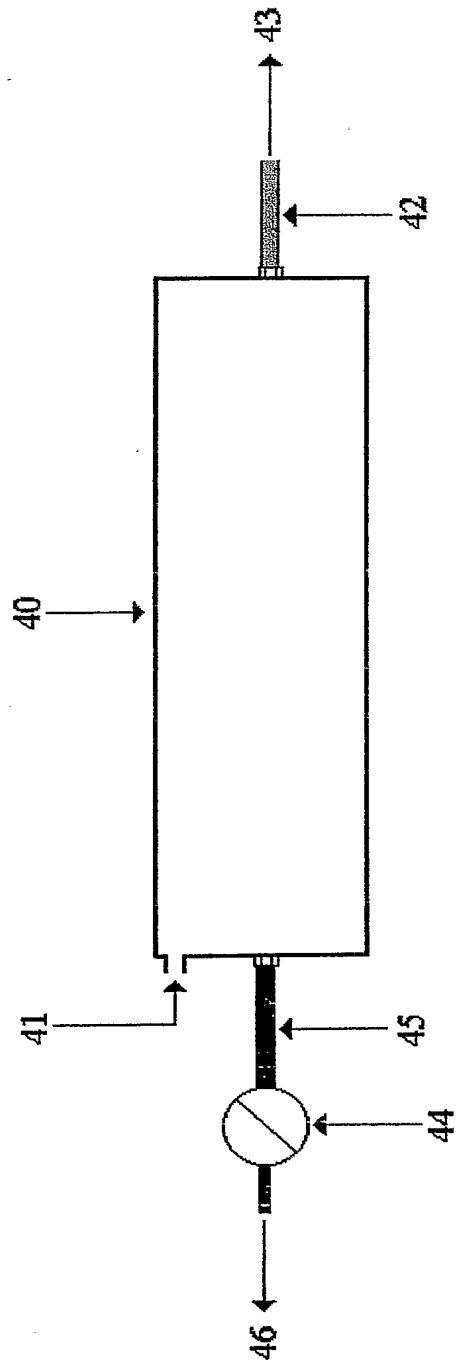
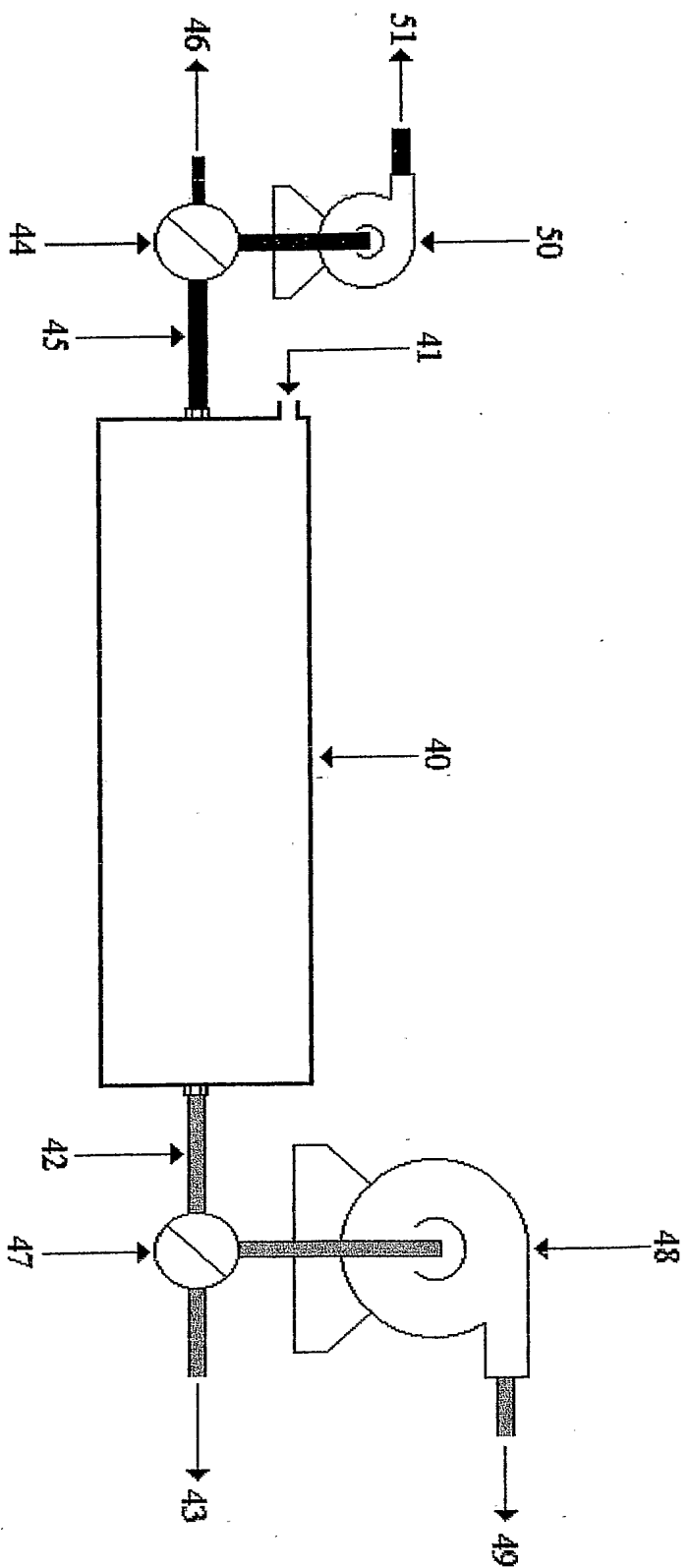


Figure 7





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Figure 8

